

Date: Tuesday, 12/5/2006 8:14:18 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE BLOCK
Job Number	: 29770		
Estimate Number	: 10324		
P.O. Number	: N/A	Part Number	: D1049
This Issue	: 12/5/2006 S.O. No. : N/A	Drawing Number	: D1049 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 27073	Material	: N/A
Written By	:	Due Date	: 1/15/2007
Checked & Approved By	: <u>JS 06/12/05</u>	Qty:	50 Um: Each
Comment	: Est RevC 02.04.10 Re-format NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0750X00250	6061-T6 Bar .750 x .250
-----	--------------------	-------------------------



Comment: Qty.: 0.1749 f(s)/Unit Total : 8.7465 f(s)
 Material: 6061-T6 bar .750 wide x .250 thick.
 Batch M19380

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
 Cut Blanks: 2.000" long

JS 06/12/09

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio FA217 & Dwg D1049

2-Deburr

JS 06/12/10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JS 06/12/10

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

JS 06/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 27/01/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:14:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BLOCK

Job Number: 29770

Part Number: D1049

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.R./J 06/12/21

49

20

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

H.L./J 07/01/03

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/1/03 49

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5709*

PC 7/1/03 49

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

01.01.05

Job Completion



4 27.01.05

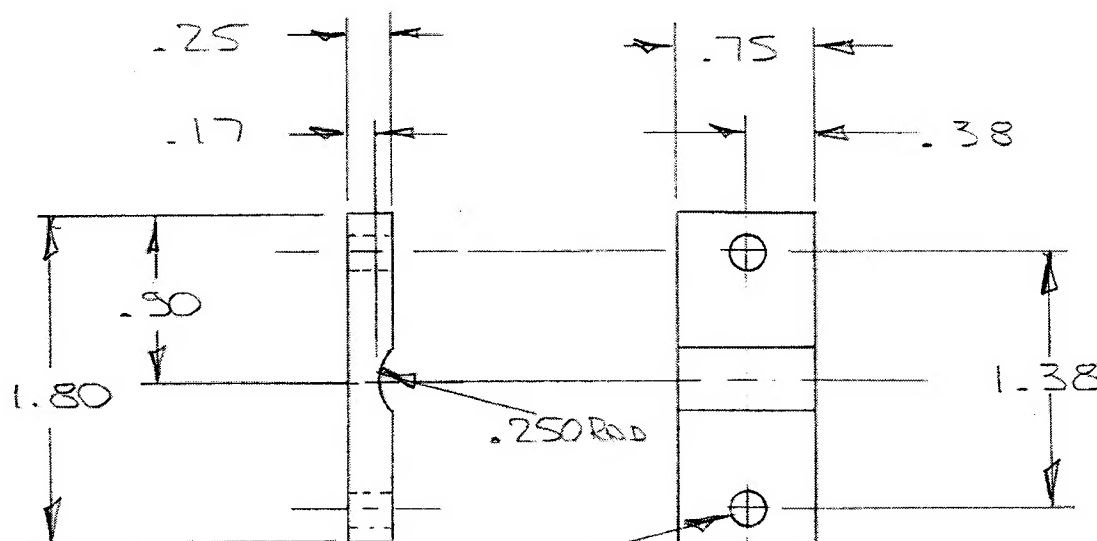
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D1049 PAR #: N/A Fault Category: CWC NCR: Yes No DQA: AA Date: 07.01.05
 QA: N/C Closed: AA Date: 07.01.05

NCR: 29770		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.12.21	60	1 part found with a deep kink on the side approximately .040 deep. R.C. - mat'l handling: strong	<u>[Signature]</u> 06.12.21 05/04/2	Scrap: destroy	<u>[Signature]</u>	<u>[Signature]</u> 06.12.21	<u>[Signature]</u> 06.12.21 05/04/2	<u>[Signature]</u> 06.12.21

NOTE: Date & initial all entries

RELEASED
97/09/02 BW



.203 DIA.
TYP

MATERIAL : 5052-H32

FINISH : POWDER COAT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 29770

REVISION		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC/VENDOR	
DRAWN				BASIC CODE		CONTRACT NO.				DATE		DART		DART AERO ACCESSORIES INC.	
APPROVED				Q=HOLE D=NO OF SHEETS E=COUNTERSINK		LENGTH DASH NO. W=SPOTWELD		DESIGN		1992		VANCOUVER		CANADA	
DESCRIPTION		REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		STRESS		TITLE		SADDLE		CODE		DWC NO.	
OF		GENERAL		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .001 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER IN. = 8 - 32 UNF 5. HOLES PER AND 10087		1. TOLERANCES — .001 ± .003 2. ANGLES .001 ± .010 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL H/C CENTRE LINES .005		8A=MS20470AD 8B=MS20476AD		REV.		D1049			
CHANGE		UNITS		REPORT ALL DISCREPANCIES — DO NOT SCALE		CLIENT		SCALE		SHT		OF			

